

WHAT IS CLAIMED IS:

1. A combination of grinding ring and grinding wheel, wherein:

the grinding ring has a centrally defined hole, a tubular extension extending from a periphery defining the hole, an annular extension extending from an outer periphery of the tubular extension, a skirt formed adjacent to the annular extension, teeth formed by pressing at a joint between the annular extension and the skirt and barbs each formed on a free end of the teeth, and

the grinding wheel is made of cloth so that the teeth together with the bars are able to extend into the grinding wheel when the skirt is pressed and engagement between the grinding ring and the grinding wheel is enhanced by applying an adhesive.

2. The combination of the grinding ring and the grinding wheel, wherein:

the grinding ring has a centrally defined hole, a tubular extension extending from a periphery defining the hole, an annular extension extending from an outer periphery of the tubular extension, a skirt formed adjacent to the annular extension, teeth formed by pressing at a joint between the annular extension and the skirt and barbs each formed on a free end of the teeth, and

the grinding wheel is made of cloth and has an aperture in communication and alignment with the hole of the grinding ring, wherein a disk is sandwiched between the grinding ring and the grinding wheel and has a through hole in alignment with the aperture so that the teeth together with the bars are able to extend into the disk and the grinding wheel when the skirt is pressed and engagement between the grinding ring and the grinding wheel is enhanced by applying an adhesive.

3. The combination of the grinding ring and the grinding wheel, wherein:

the grinding ring has a centrally defined hole, a tubular extension extending from a periphery defining the hole, an annular extension extending from an outer periphery of the tubular extension, a skirt formed adjacent to the annular extension, teeth formed by pressing at a joint between the annular extension and the skirt and barbs each formed on a free end of the teeth, and the grinding wheel is made of cloth stacked on top of one another to form a circle and has an aperture in alignment with the hole of the grinding ring so that the teeth together with the bars are able to extend into the grinding wheel when the skirt is pressed and engagement between the grinding ring and the grinding wheel is enhanced by applying an adhesive.